

Work Order ID 66000

Tuesday, February 01, 2011 12:55:07 PM



Page 1

Item ID: D3564-3

Revision ID:

Item Name: Wearshoe

Start Date: 2/1/2011

Required Date: 2/4/2011

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: D Prog
Rev: D 2-Deburr if necessary

B11-2-2

(B1)

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

B11-2-2

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

Suloxloz

(SLO)

split

(3)

W

Work Order ID 66000

Tuesday, February 01, 2011 12:55:07 PM



Page 2

Item ID: D3564-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 2/1/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

0.00

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157

SB 11/02/02

11

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

Ensure joggle as per dwg D3429

8/1/02/02

tu

150



Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

Qty Description Batch A/R 2059B Hardcoat
M116631 Weld hardcoat as per Dwg D3437

EL 11-2-3 x3

Work Order ID 66000

Tuesday, February 01, 2011 12:55:07 PM

Page 3

Item ID: D3564-3

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 2/1/2011 Start Qty: 6.00

Required Date: 2/4/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QS1004- ground welds

0.00



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00



Powdercoat

Powder Coating

Memo

0.00

START TIME:

3:15

OVEN TEMPERATURE:

3:45

M115128

+3

3

BL 11-02-3.

Work Order ID 66000

Tuesday, February 01, 2011 12:55:07 PM



Page 4

Item ID: D3564-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 2/1/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

B.11/25 SL 32

200

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/2/3 SL 30

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/04 J

MF
11-02-04

Picklist Print

Tuesday, February 01, 2011 12:55:04 PM

Page 1

Work Order ID: 66000

Parent Item: D3564-3

Parent Item Name: Wearshoe



Start Date: 2/1/2011

Required Date: 2/4/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S16GA

Purchased

No

100

sf

241.5000

1.1

6.947368

12.1



HB 11-2-2

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT

241.5

111323

0

116623

241.5

116623

11

| | | |
|-----------------------|--------|-------------------------|
| DART AEROSPACE LTD | | Work Order: <i>6600</i> |
| Description: Wearshoe | | Part Number: D3564-3 |
| Inspection Dwg: D3564 | Rev: D | Page 1 of 1 |

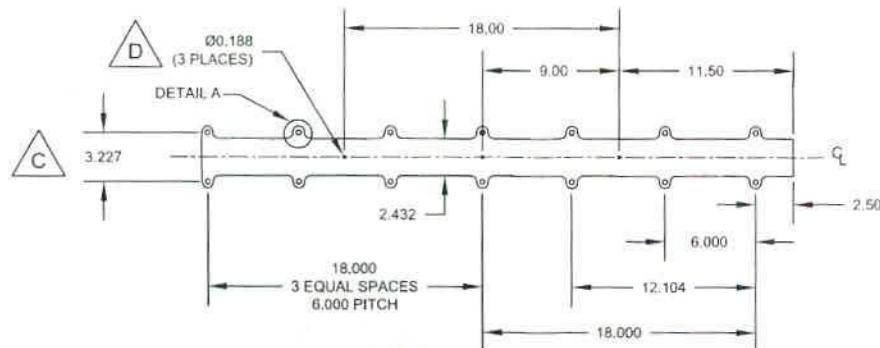
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

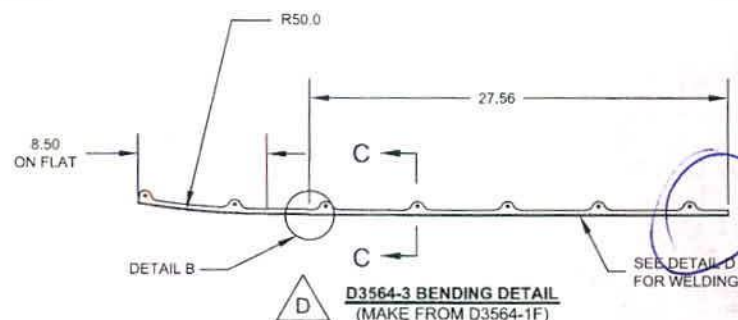
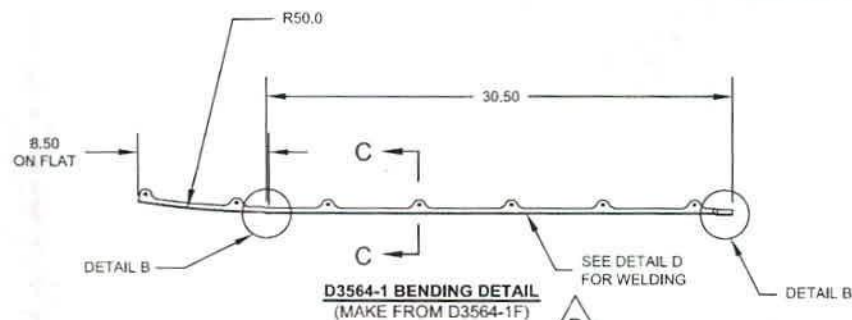
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 3.227 | +/-0.010 | 3.226 | X | | V 1802 | |
| 2.432 | +/-0.010 | 2.439 | X | | V | |
| 2.50 | +/-0.030 | 2.50 | X | | V | |
| 6.000 | +/-0.010 | 6.00 | V | | T 1801 | |
| 12.104 | +/-0.010 | 12.104 | b | | T | |
| 18.000 | +/-0.010 | 18.000 | X | | T | |
| 18.000 | +/-0.010 | 18.00 | X | | T | |
| 18.00 | +/-0.030 | 18.00 | P | | T | |
| 9.00 | +/-0.030 | 9.00 | P | | T | |
| 11.50 | +/-0.030 | 11.50 | L | | T | |
| 0.300 x 0.300 | +/-0.010 | 0.304 x 0.309 | V | | V | |
| Ø0.188 | +0.005/-0.001 | .191 | X | | V | |
| R0.375 | +/-0.010 | .375 | X | | V | |
| 0.063 | +/-0.010 | .060 | X | | V | |
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| | | | |
|------------------------|-----------------------|---------------------|-----|
| Measured by: <i>IB</i> | Audited by: <i>S</i> | Prototype Approval: | N/A |
| Date: <i>11-2-2</i> | Date: <i>11/02/02</i> | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------|-----------------|-----------|
| A | 07.09.06 | New Issue | KJ/JLM | |
| B | 08.09.04 | Dwg Rev updated | KJ/DC <i>24</i> | <i>DA</i> |



D3564-1F FLAT PATTERN



D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT CL

Wt 66000

| WEIGHTS: | |
|----------|----------|
| D3564-1 | 1.85 lbs |
| D3564-3 | 1.85 lbs |
| D3564-5 | 1.93 lbs |
| D3564-7 | 1.26 lbs |
| D3564-9 | 1.85 lbs |
| D3564-11 | 1.85 lbs |
| D3564-13 | 0.38 lbs |
| D3564-15 | 0.80 lbs |

RELEASED

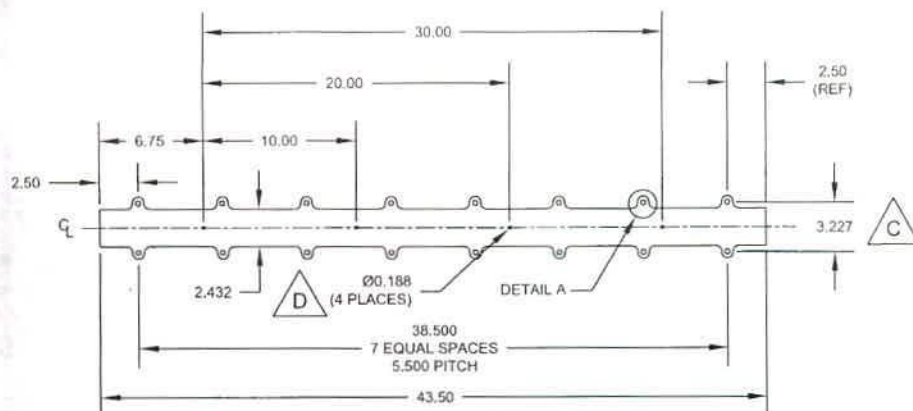
07.09.04

| D | UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8; UPDATE NOTES: PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B8,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE | CB | 07.08.21 |
|------------|--|----|----------|
| C | MOVE TAB OUTBOARD, DETAIL A | PH | 07.04.17 |
| B | ADD AMS 5513 AND AMS 5524 | PH | 07.03.20 |
| A | NEW ISSUE | PH | 07.08.21 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PH | | |
| DRAWN | CB | | |
| CHECKED | PH | | |
| MFG. APPR. | PH | | |
| APPROVED | PH | | |
| DE APPR. | PH | | |
| DATE | 07.08.21 | | |

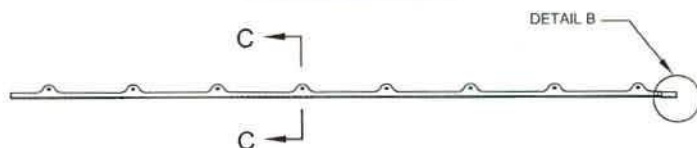
| | |
|--|------------------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D3564 | REV. D SHEET 1 OF 3 |
| TITLE WEARSHOE | SCALE 1:8 |

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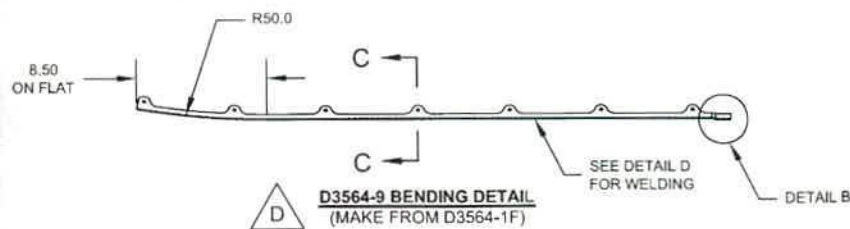
8 7 6 5 4 3 2 1



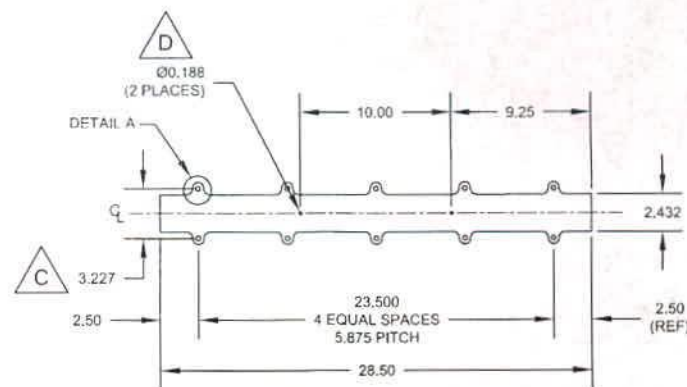
D3564-5F FLAT PATTERN



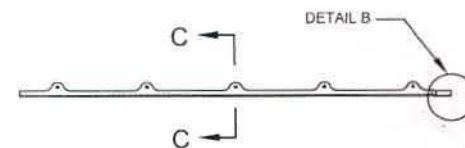
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



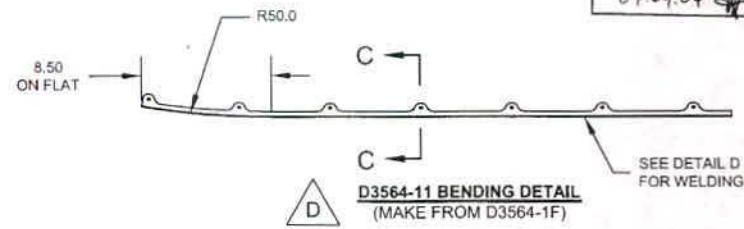
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

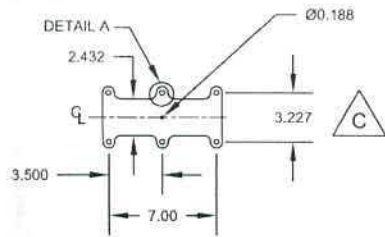
07.09.04

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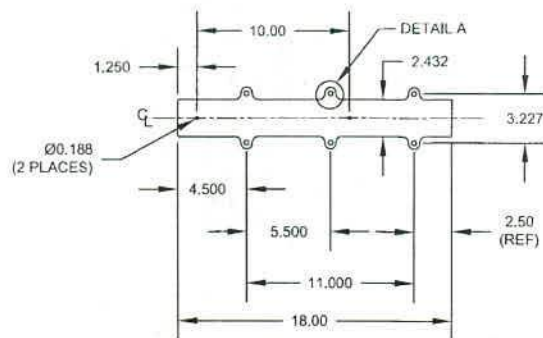
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|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | CB | | |
| CHECKED | PH | DRAWING NO. | REV. D |
| MFG. APPR. | PH | D3564 | SHEET 2 OF 3 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | WEARSHOE | 1:8 |
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8 7 6 5 4 3 2 1

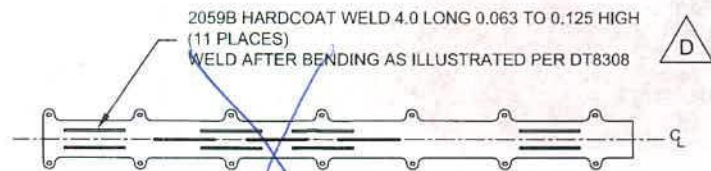
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D3564-13F FLAT PATTERN

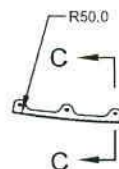


D3564-15F FLAT PATTERN

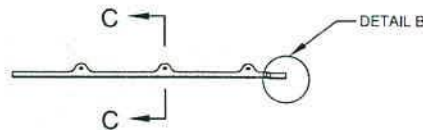


DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

see attached



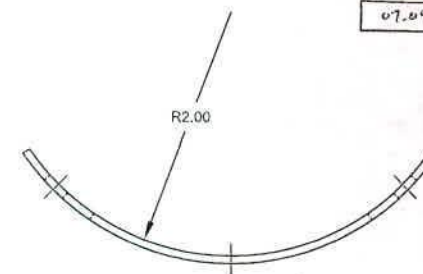
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



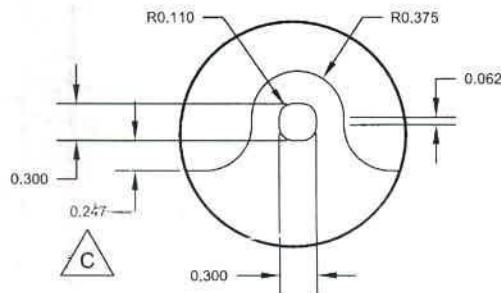
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

RELEASED

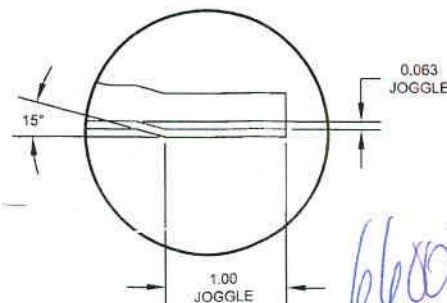
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

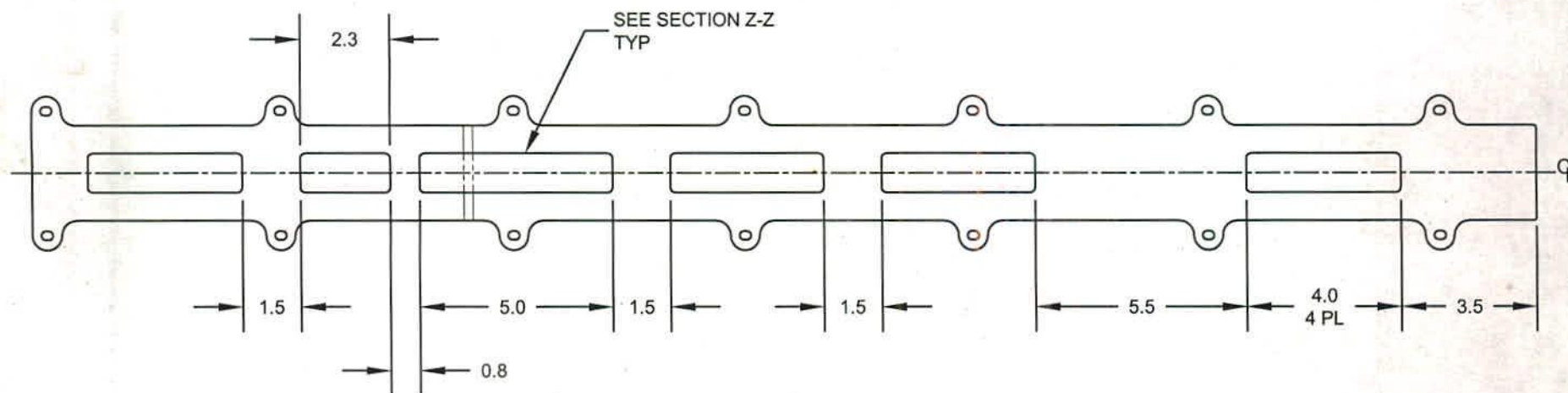
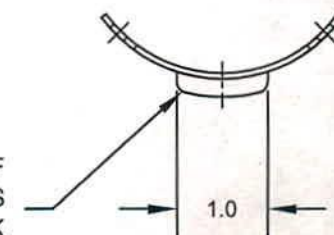
66000

| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE LTD | |
| DRAWN | CB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PH | DRAWING NO. | REV. D |
| MFG. APPR. | PH | D3564 | SHEET 3 OF 3 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | WEARSHOE | 1:8 |
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8 7 6 5 4 3 2 1



SECTION Z-Z



DETAIL D
(D3564-3 CUSTOM WELDING DETAIL)